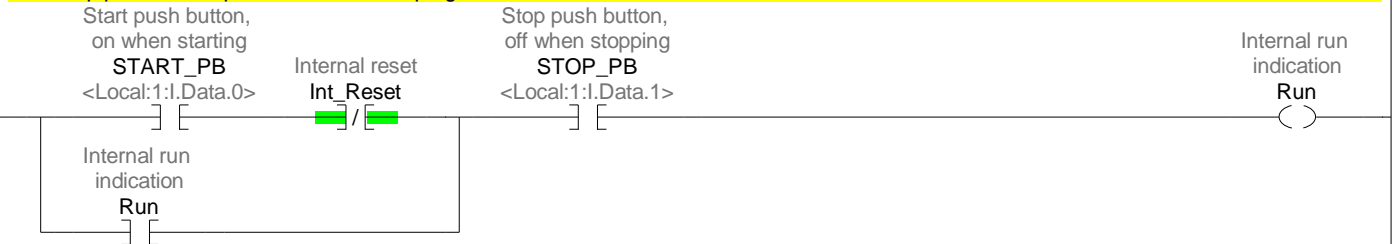


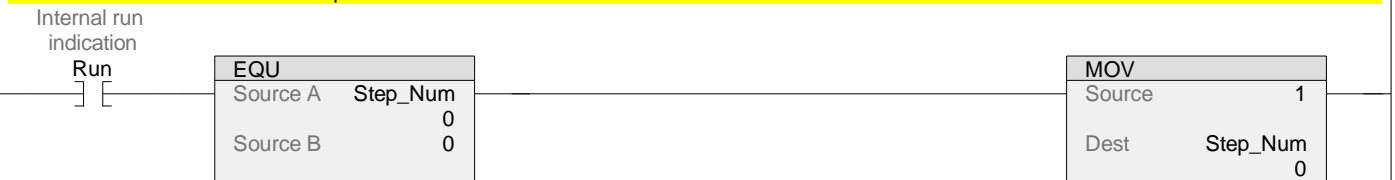
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Part Oiler with Move-based sequencer

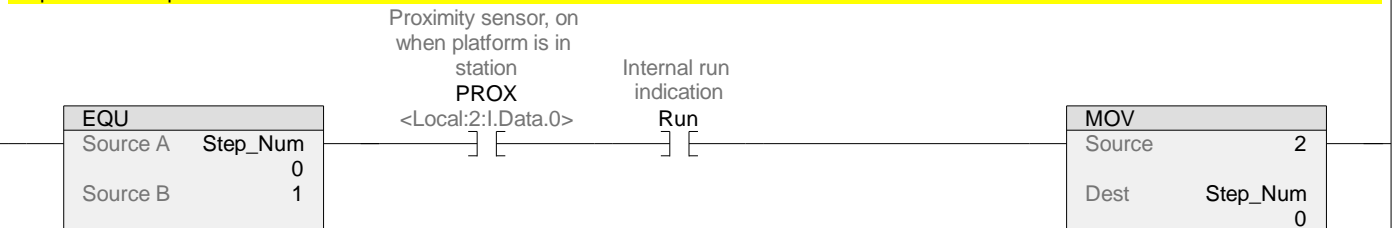
Start/stop/pause. Start prevented if reset in progress.



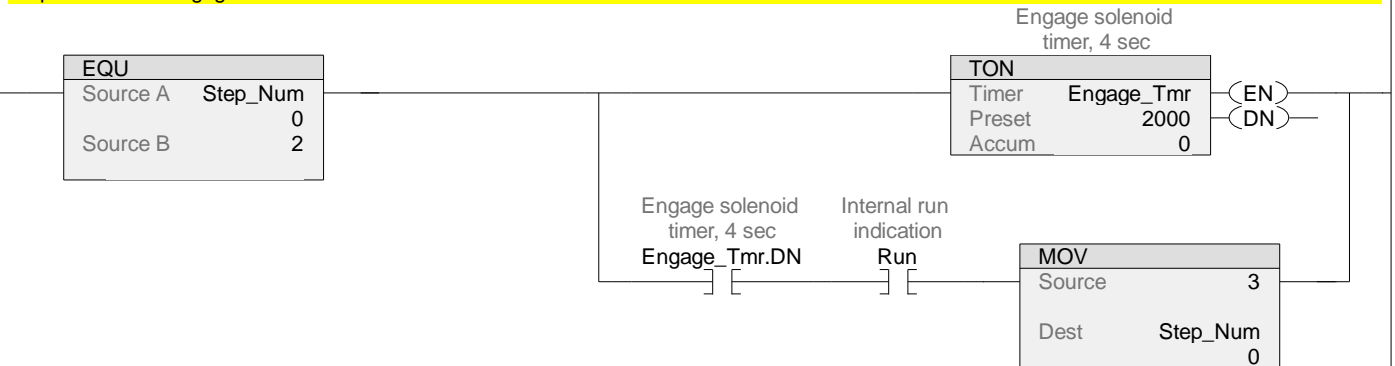
Generate transition out of initial step



Step 1 - Wait for part.



Step 2 - Wait for engage.



Step 3 - Lower Oiler

4

EQU	
Source A	Step_Num
	0
Source B	3

Limit switch, on
(closed) when oiler
tip is in lowered
position
LS2
<Local:2:I.Data.2>

MOV	
Source	4
Dest	Step_Num
	0

Step 4 - Squirt Oil

5

EQU	
Source A	Step_Num
	0
Source B	4

Oil squirt timer,
0.5 sec

TON	
Timer	Squirt_Tmr
Preset	500
Accum	0

EN
DN

Oil squirt timer,
0.5 sec
Squirt_Tmr.DN

MOV	
Source	5
Dest	Step_Num
	0

Step 5 - Raise Oiler

6

EQU	
Source A	Step_Num
	0
Source B	5

Limit switch, on
(closed) when oiler
tip is in raised
position
LS1
<Local:2:I.Data.1>

MOV	
Source	6
Dest	Step_Num
	0

Step 6 - Part Leaves. Then jump to step 1

7

EQU	
Source A	Step_Num
	0
Source B	6

Proximity sensor, on
when platform is in
station
PROX
<Local:2:I.Data.0>

MOV	
Source	1
Dest	Step_Num
	0

